

Work Order ID 105510

105510

Page 1

August-08-13 7:54:44 AM

D2698

Item ID: D2698

Accept

N900040100

Setup Start *NS1*

Revision ID:

B 105510

Stop *NS2*

Item Name: Leg Clevis

Start Date: 8/08/13

Start Qty: 1.00

4 *16*

Cust Item ID:

Requir. Date: 8/09/13

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2698

Rev B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER FILE

PROG REV: B

DWG REV: B

6061-250

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

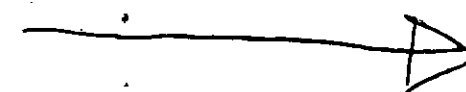
QC

Memo

0.00

Quality Control

PTO



Work Order ID 105510

105510

Page 2

August-08-13 7:54:44 AM

Item ID: D2698

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Leg Clevis

Start Date: 8/08/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/09/13

Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

Black Sandtex (Ref:4.3.5.7) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320°F

1000

m126125

14 X 8 M / 13/08/15

DAS
05
2-83

13-08-14



Work Order ID 105510

105510

Page 3

August-08-13 7:54:44 AM

Item ID: D2698

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Leg Clevis

Start Date: 8/08/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/09/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

14x d ll 13/08/15

170

Identify as per dwg & Stock Location: STO16 0.00

170

Packaging

Memo

0.00

Packaging

14x M. R. 13-08-15

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

13/8/2013

MCS 13-08-16

Picklist Print

August-08-13 7:54:44 AM

Page 1

Work Order ID: 105510

Parent Item: D2698

Parent Item Name: Leg Clevis

Start Date: 8/08/13

Required Date: 8/09/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-08-07 JLM VERIFIED BY:DD

Component Item ID/ Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No				sf	107.3500		0.14	.56	13.08.10	

6061T6 SHEET .250

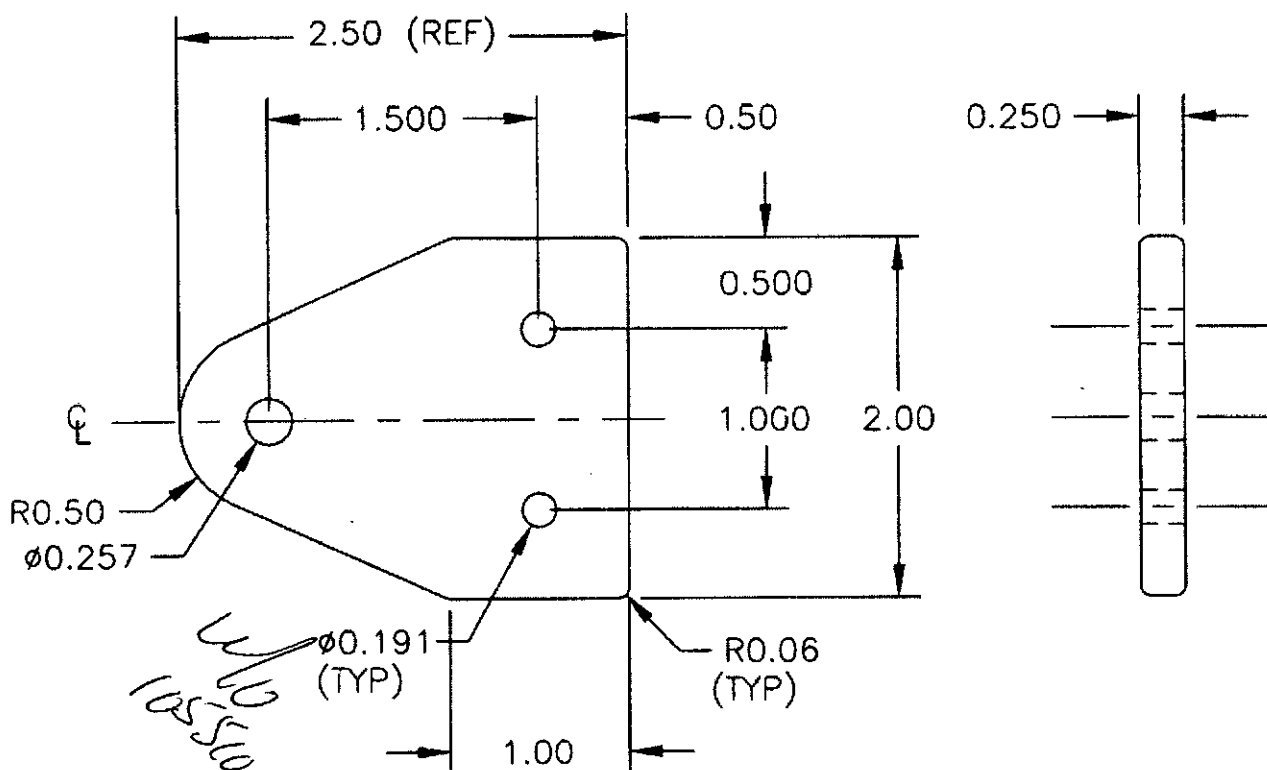
Location	Loc Qty	Loc Code
MAT021	107.35	
116808	23.8	
121194	26.3	
125024	57.25	

125024



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2698	REV. B SHEET 1 OF 1
DATE 99.10.20		TITLE LEG CLEVIS	SCALE 1:1
A	97.09.10	NEW ISSUE	
B	99.10.20	UPDATE TOLERANCE AND FINISH	

RELEASED
99.11.02 *KE*



NOTE: DEBURR ALL EDGES R0.030-R0.060
PART IS SYMMETRIC ABOUT CENTERLINE
MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8
OR QQ-A-200/8 OR QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *[Signature]* Date: 13/08/22QA Closed: *[Signature]* Date: 13/8/21

Work Order: <u>105510</u> Part No. <u>D2698</u> NCR No. <u>13-29105</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	13/8/22	100		φ0.191 holes are oversized from waterjet up to φ0.205", tapered.	CP 13/8/22	Acceptable. Ensure there are no ridges from waterjet, Remove if necessary Ensure there are no ridges from waterjet, Remove if necessary	Ae 13.08.22	DAS 27 9-89 13.8.20	DAS 16 8-89 13/08/20		
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

